

Work Order ID 84310

84310

Page 1

Item ID: D2958

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window

Start Date: 09/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/05 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2958

Rev E

100.

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1/8" Polycast II
flexiglass.

4 0 Jm
12-5-17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jm
12-5-17

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

4 0 Oh
12/05/31
P10 →

Dart Aerospace Ltd

W/O: 84310		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2958 PAR #: _____ Fault Category: Water Jet NCR: Yes No DQA: 2/10/10 Date: 12/07/10
 Resolution: 1 Disposition: Scrap QA: N/C Closed: CK Date: 12/7/10

NCR: 12-1573		WORK ORDER NON-CONFORMANCE (NCR) 82.01						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/08	120	TOO MANY MARKS FROM WATERJET. BLOWBACK R.C. operator didn't place Plastic Blkdy under mat.	S 12/07/04 02/04/08	SCRAP 1 PART. INFORM WATERJET OPERATOR TO USE PLASTIC GRATING TO AVOID BLOWBACK.	DL 12/06/08	S 12/07/04	S 05/04/08 12/07/04	S 12/09/04
		lack of training						

NOTE: Date & initial all entries

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg D2958 and Folio FTA005Dwg. Rev. <u>E</u> Folio Rev. <u>B</u>	0.00 0.00				<u>x3</u>			<u>Wk</u> <u>12/06/28</u>
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Check product for scratches mal-formation or any other non conformances.	0.00 0.00				<u>x3</u>			<u>Wk</u> <u>12/06/28</u>
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>(x3)</u>			<u>Wk</u> <u>12/06/28</u>

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required Wrap in protective film

DL
12/06/00

170

0.00

170

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

5/26/04

180

0.00

180Identify as per dwg & Stock Location: *5208*

Packaging

Memo

0.00

Packaging

3x *80*
12-7-8

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

CK 12/7/10

MF
12-07-05

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

May-09-12 1:38:39 PM

Page 1

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84310

Parent Item: D2958

D2958

Parent Item Name: Window

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP E: 01.09.25 Done by outside contract SM
IPP F: 07.06.26 Thermoform in house DL
IPP G: 07.09.28 Rev E dwg EC verified by: DD
IPP H: 08.11.24 Step 8 revised per w/o 41134 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	73.2634	2.58	10.86316			

MACR ICS 125

1/8" Polycast II Sheet

**

Location	Loc Qty	Loc Code
MAT019	73.2634	
110633	3	
117324	0.2467	
117431	10.7967	
119591	59.22	

~~119591~~

Jm
12-5-17

Dart Aerospace Ltd

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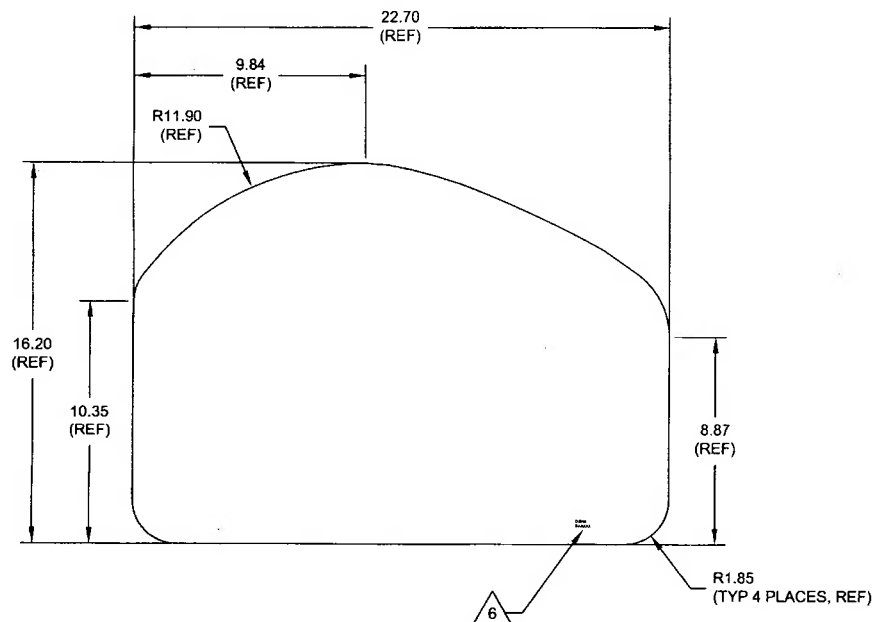
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D2958 FLAT PATTERN

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84310 MLJ

12/05/09

RELEASED
07.04.22

REV.	DESCRIPTION	BY	DATE
E	UPDATE DIMS PER PAR 188	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2958
TITLE WINDOW
REV. E
SHEET 1 OF 1
SCALE 1:5

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